

Date: Tuesday, 4/4/2006 1:35:46 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 26532		
Estimate Number	: 10699		
P.O. Number	: N/A	Part Number	: D3391025
This Issue	: 4/4/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3391 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26531	Drawing Revision	: D
	Type : LANDING GEAR	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/24/2006
Checked & Approved By	: <u>06.04.04</u>	Qty:	1 Um: Each
Comment	: Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manufacturing Instructions JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 24315 (D6014-104) M8 06/04/06

Identify as D3391-3

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: DM8 06/04/07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M806/04/07

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: D

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

06/05/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:35:46 PM
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Process Sheet

Customer: CU-DAR001- Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26532

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Trk 06/05/10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/05/10 x1

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP06-5-25

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-5-25

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

06-05-26

DP06-5-25

DP06-5-26

06-05-26

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-29

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

IT 06-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:35:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26532

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9-m 06-06-14 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/06/14 (1)

14.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert

M17905

15.0

NAS1330C3KB166



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert

M100732

16.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB266 Insert

M17905

or NAS1330C3KB266

17.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB316 Insert

M17905

or NAS1330C3KB316

DL 06/06/14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:35:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26532

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B25381

19.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	M100651

20.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	M18822

21.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	M100186

PL 04/04/2006

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

DL

04/04/14

①

2-Install Aft Cap as per Dwg D3391



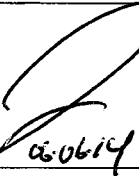
A/R Sikaflex-241/-291 M101193


Sikaflex expiry date: 11/06

PL 04/04/2006

①

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-06-14	22	QCS inspect + insert + threads; installation.		06-06-15	1		 06-06-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:35:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26532

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MM 06.06.28 (1)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

06/06/28

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/29 (1)

Job Completion



06.06.28

Dart Aerospace Ltd

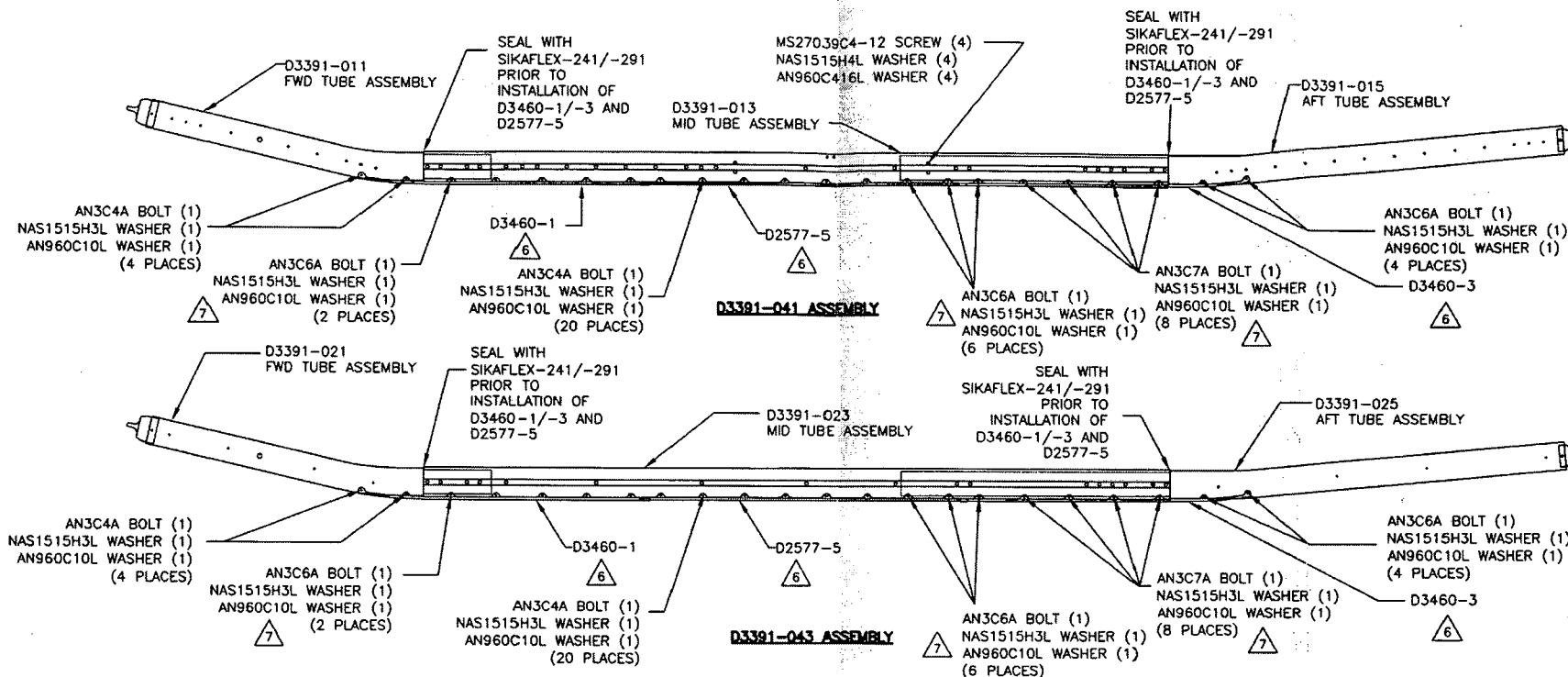
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.
- C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- DO NOT TORQUE, HAND TIGHTEN ONLY

△

RELEASED

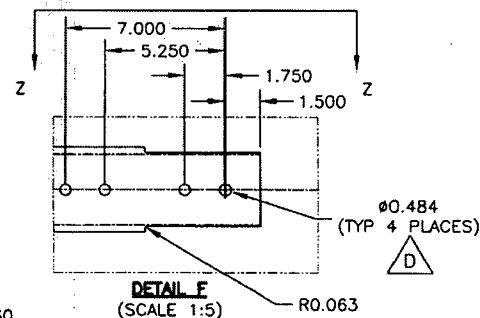
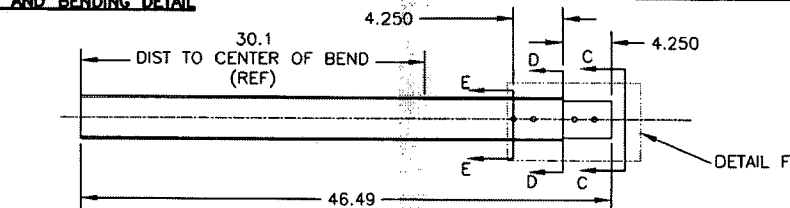
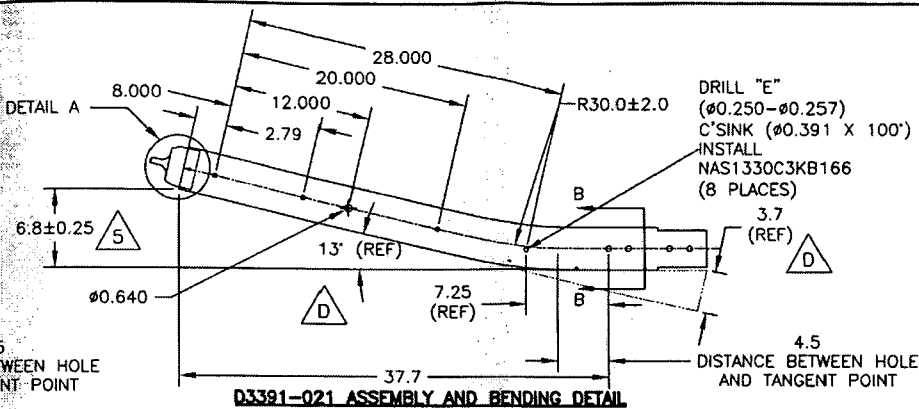
06-01-27

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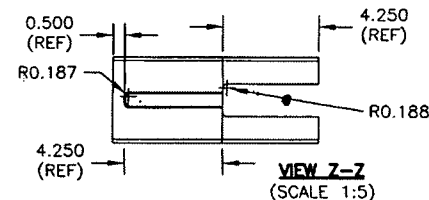
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DESIGN	D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
	C	05.09.27	LENGTHEN AFT EXTENSION
	B	05.06.10	DRAWING UPDATES
	A	05.02.07	NEW ISSUE
DRAWN BY	PH	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	PH	PH	DRAWING NO. D3391
DATE	06.01.23	TITLE	412 FLOAT SKIDTUBE
		SCALE	NTS

NO. 26532
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING
SHOP COPY

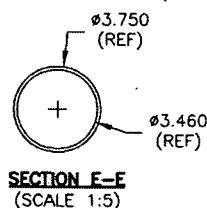


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06-01-27

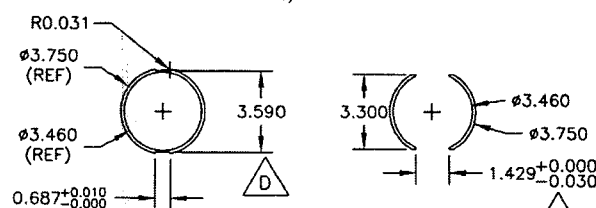


QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	INS1330C3KB166	INSERT

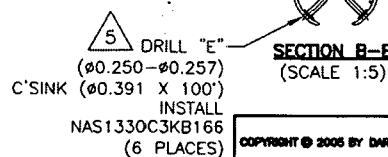
-1 DRILLING AND CUTTING DETAIL
(FROM D6013-047 SKIDTUBE MATERIAL)



SECTION E-E
(SCALE 1:5)



SECTION D-D
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)

SECTION C-C
(SCALE 1:5)

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DESIGN	DW
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CHECKED

DATE
06.01.23

DRAWN BY
DH

APPROVED 

DART DART AEROSPACE USA, INC.
PORTLAND, OR 97208

DRAWING NO.
D3391

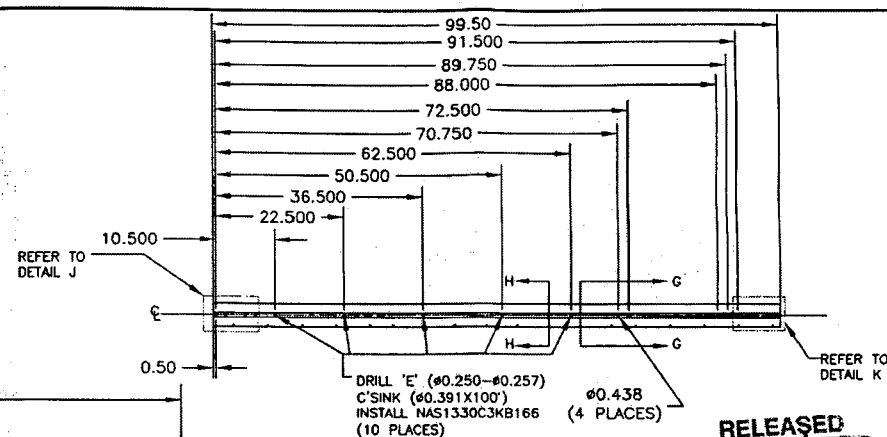
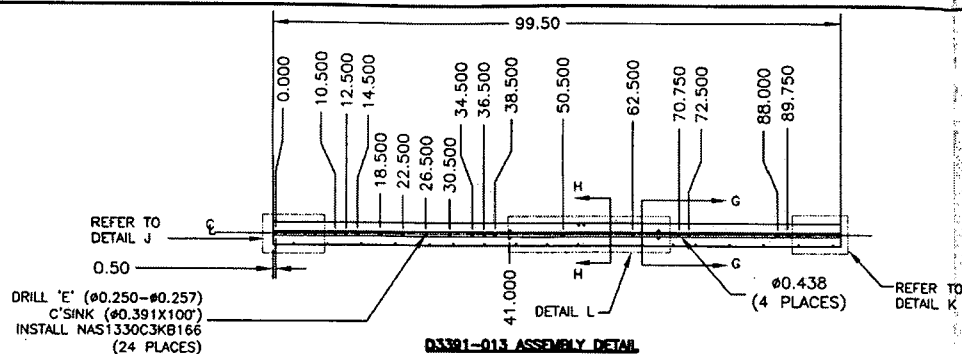
TITLE	412 FLOAT SKIDTUBE
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AEROSPACE USA, INC.
FORT HADLOCK, WA

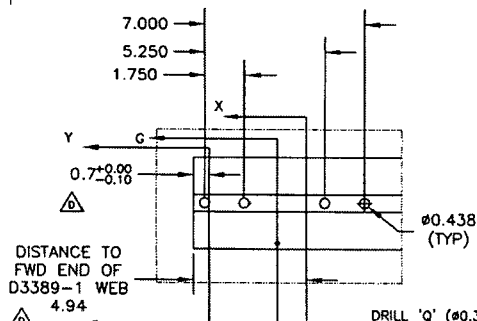
REV. C

SHEET 2 OF 5

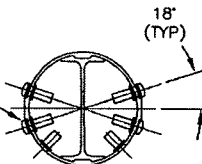
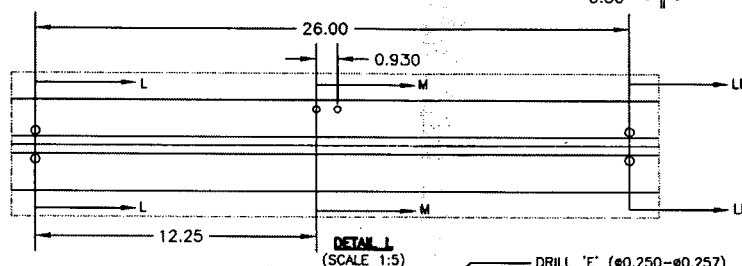
SCALE
1:10



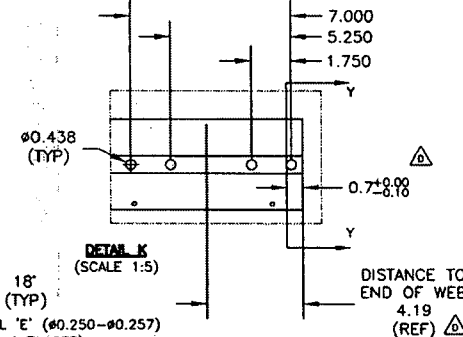
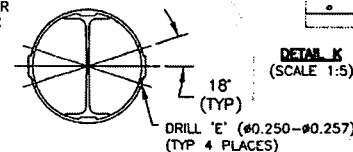
RELEASED
06-01-27



DRILL 'O' (#0.332-#0.338)
INSTALL NAS1329C4KB140 INSERT
MS27039C4-08 SCREW
NAS1515H4L WASHER
AN960C416L WASHER
(TYP 4 PLACES)



DRILL 'E' (#0.250-#0.257)
C'SINK (#0.391X100')
INSTALL NAS1330C3KB116 INSERT
MS27039C1-09 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 4 PLACES)



D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

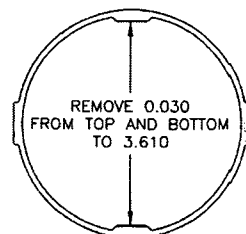
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION

2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

SECTION I-I
(SCALE 1:4)

SECTION II-II
(SCALE 1:4)

SECTION II-II
(SCALE 1:4)



SECTION X-X
(SCALE 1:2)

REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

SECTION Y-Y
(SCALE 1:4)

SECTION Z-Z
(SCALE 1:4)

SECTION W-W
(SCALE 1:4)

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DESIGN
PH

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PH

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PORT HADLOCK, MA

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#

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#

DRAWING NO.
D3391

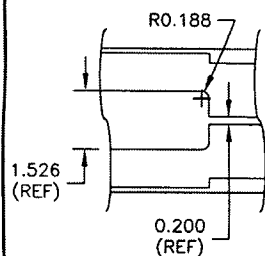
REV. D
SHEET 3 OF 5

DATE
06.01.23

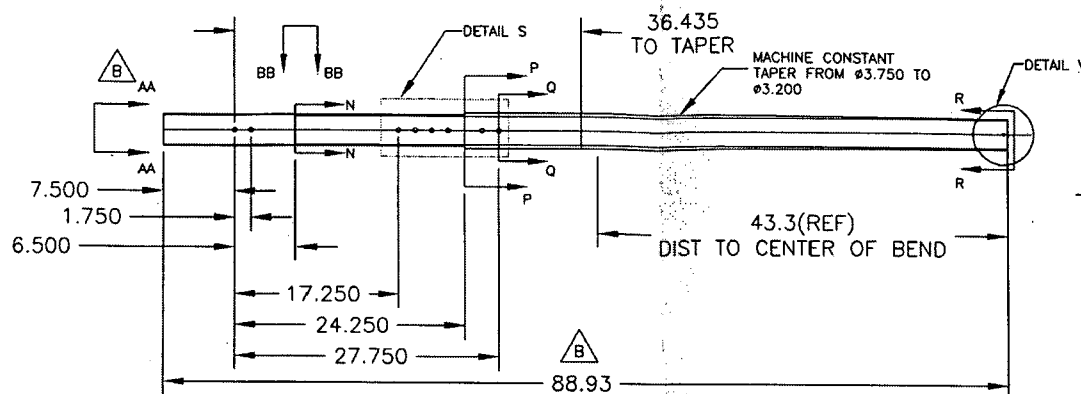
TITLE
412 FLOAT SKIDTUBE

SCALE
1:20

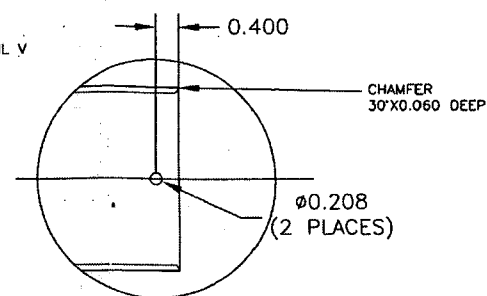
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
26532



VIEW BB-BB
(SCALE 1:3)



D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

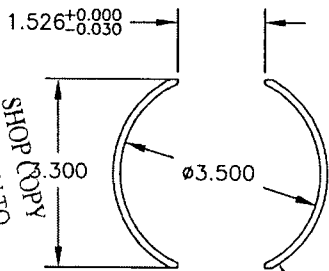


DETAIL V
(SCALE 1:2)

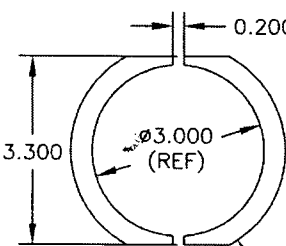
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06.01.23

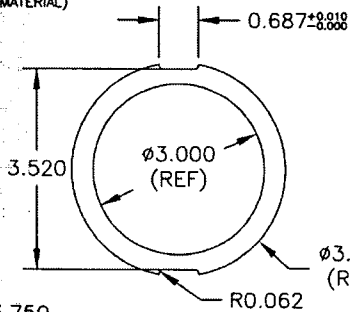
NO. 26532
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE



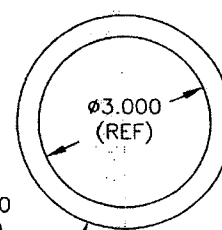
SECTION AA-AA
(SCALE 1:2)



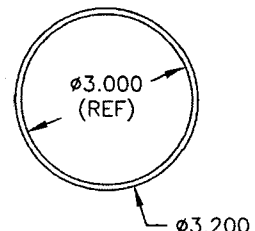
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(SCALE 1:2)



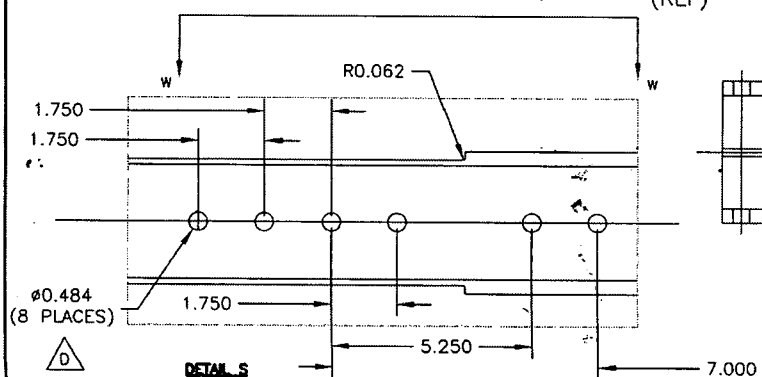
SECTION P-P
(SCALE 1:2)



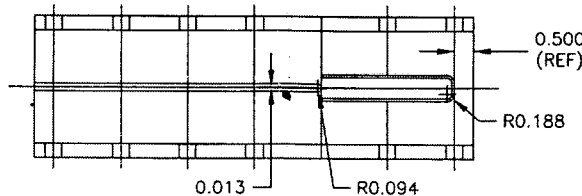
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)

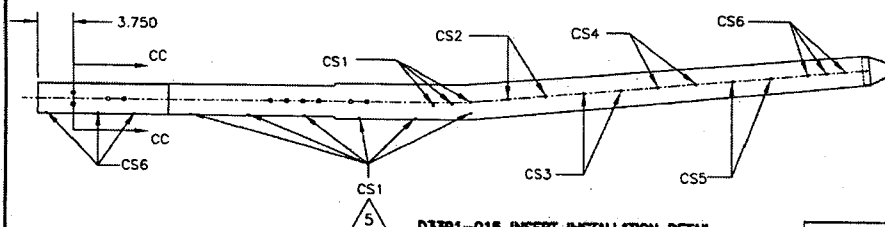
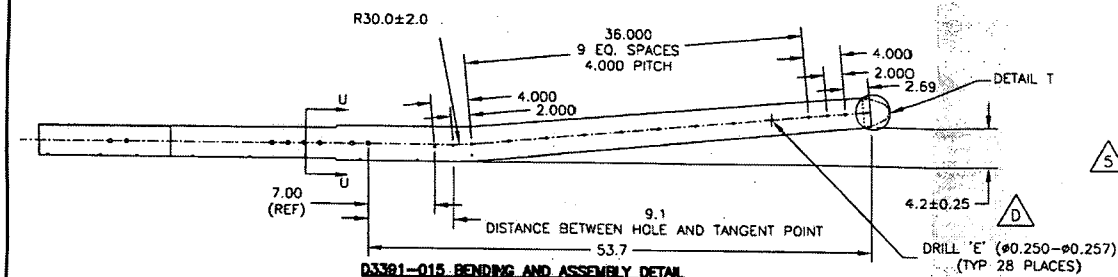


VIEW W-W
(SCALE 1:3)

DESIGN PH		DRAWN BY PH		DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	
CHECKED	APPROVED	CHECKED	APPROVED	DRAWING NO. D3391	REV. D
DATE 06.01.23				TITLE 412 FLOAT SKIDTUBE	SHEET 4 OF 5
					SCALE 1:12

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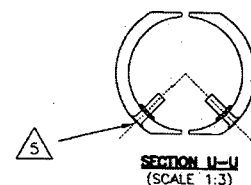
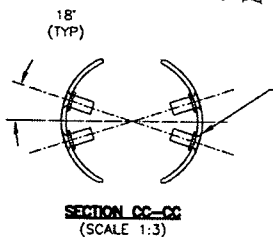
C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	4		Ø0.391	AESS10KB366
CS3	4	2	Ø0.391	NAS1330C3KB316
CS4	4	2	Ø0.391	NAS1330C3KB266
CS5	4		Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

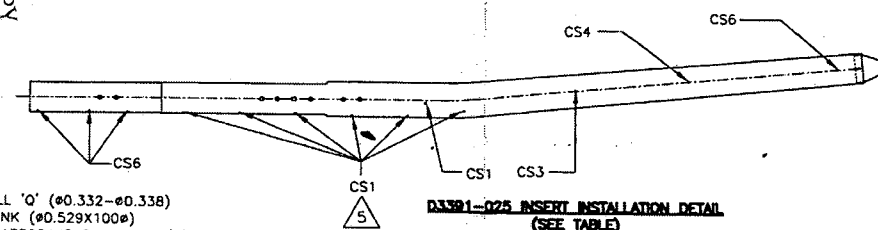
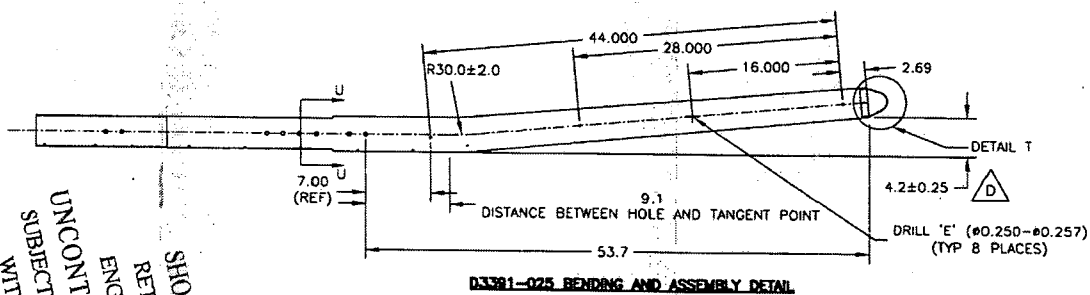
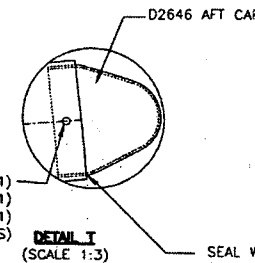
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4		NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER

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NO 26532
WORK ORDER



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)



DRILL 'Q' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100Ø)
NAS1330C4KB151 INSERT (1)
(4 PLACES)

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CHECKED	APPROVED	DRAWING NO. D3391		
DATE 06.01.23		TITLE 412 FLOAT SKIDTUBE		REV. 0 SHEET 5 OF 5 SCALE 1:12

DART AEROSPACE LTD		Work Order:	26532
Description: AFT Tube assembly		Part Number:	3391-3
Inspection Dwg: 3391	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	$\pm .010$	14.000	✓			
3.500	$\pm .010$	3.495	✓			
3.200	$\pm .010$	3.202	✓			
1.520	$\pm .000$	1.524	—			
3.300	$\pm .010$	3.295	—			
0.200	$\pm .010$	0.200	—			
20.062	$\pm .010$	20.062	—			
0.687	$\pm .010$	0.690	—			
7.500	$\pm .010$	7.495	—			
22.750	$\pm .010$	22.750	—			
35.250	$\pm .010$	35.250	—			
31.750	$\pm .010$	31.750	—			
80.484	$\pm .001$	80.485	—			
0.400	$\pm .010$	0.398	—			
3.520	$\pm .010$	3.524	—			

Measured by:	MS / <i>ms</i>	Audited by:	<i>EP</i>	Prototype Approval:	
Date:	06/04/07	Date:	06/05/10	Date:	
Rev	Date	Change	Revised by	Approved	
A		New Issue	KJ/RF		